

Date: Friday, 5/25/2007 8:19:27 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-----------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : STEP WELDMENT ASSEMBLY |
| Job Number | : 32596 | | |
| Estimate Number | : 11248 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D3438042 |
| This Issue | : 5/25/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D3438 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : LARGE FAB ASSY | Drawing Revision | : A |
| Previous Run | : 28793 | Material | : <i>N/A</i> |
| Written By | : | Due Date | : 6/12/2007 Qty: 2 Um: Each |
| Checked & Approved By | : <i>[Signature]</i> 05.05.18 | | |
| Comment | : Est A 05.05.18 New Issue KJ/JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|---------|-----------|
| 1.0 | D267334 | End Plate |
|-----|---------|-----------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| | | | |
|-----|----------|-------------|---------------|
| Qty | Part No. | Description | Batch |
| 2 | D2673-34 | End Cap | <i>B25396</i> |

14.01.06.22 2

| | | |
|-----|-------|-----------|
| 2.0 | D2561 | Lug Plate |
|-----|-------|-----------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| | | | |
|-----|----------|-------------|---------------|
| Qty | Part No. | Description | Batch |
| 2 | D2561 | Lug Plate | <i>B30384</i> |

14.01.06.22 2

| | | |
|-----|-------|----------------|
| 3.0 | D2564 | Mounting Angle |
|-----|-------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| | | | |
|-----|----------|----------------|---------------|
| Qty | Part No. | Description | Batch |
| 2 | D2564 | Mounting Angle | <i>B30464</i> |

14.01.06.22 2

| | | |
|-----|-------------|------------------------------|
| 4.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 79.63" at 34° as per Dwg D3438

2-Deburr ends

3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg D3438 using DT8343

14.01.06.22 2
14.01.06.22 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 32596

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Grind

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-06-27 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspected 07-06-27 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Q.M. 07-06-27

(2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-07-03

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last cap per dwg D3438 & grind flush

3mm 02756 welding
3mm 104721 rods

Q.M. 07-07-04

07-07-03

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/04 (2)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-07-04 (2)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Touch up alodine

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

> M.L. 07/07/04 (2X)

M 104144

07-07-05 (2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/07/66
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 32596

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



m/104733



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg 3438 and QSI 005 4.4

Mask off 0.5 each side of D2561 lugs

FL

07/07/05 (2)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/7/6 (2)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPR 32509

07/7/6 (2)

16.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

07/07/06

Job Completion



07-07-06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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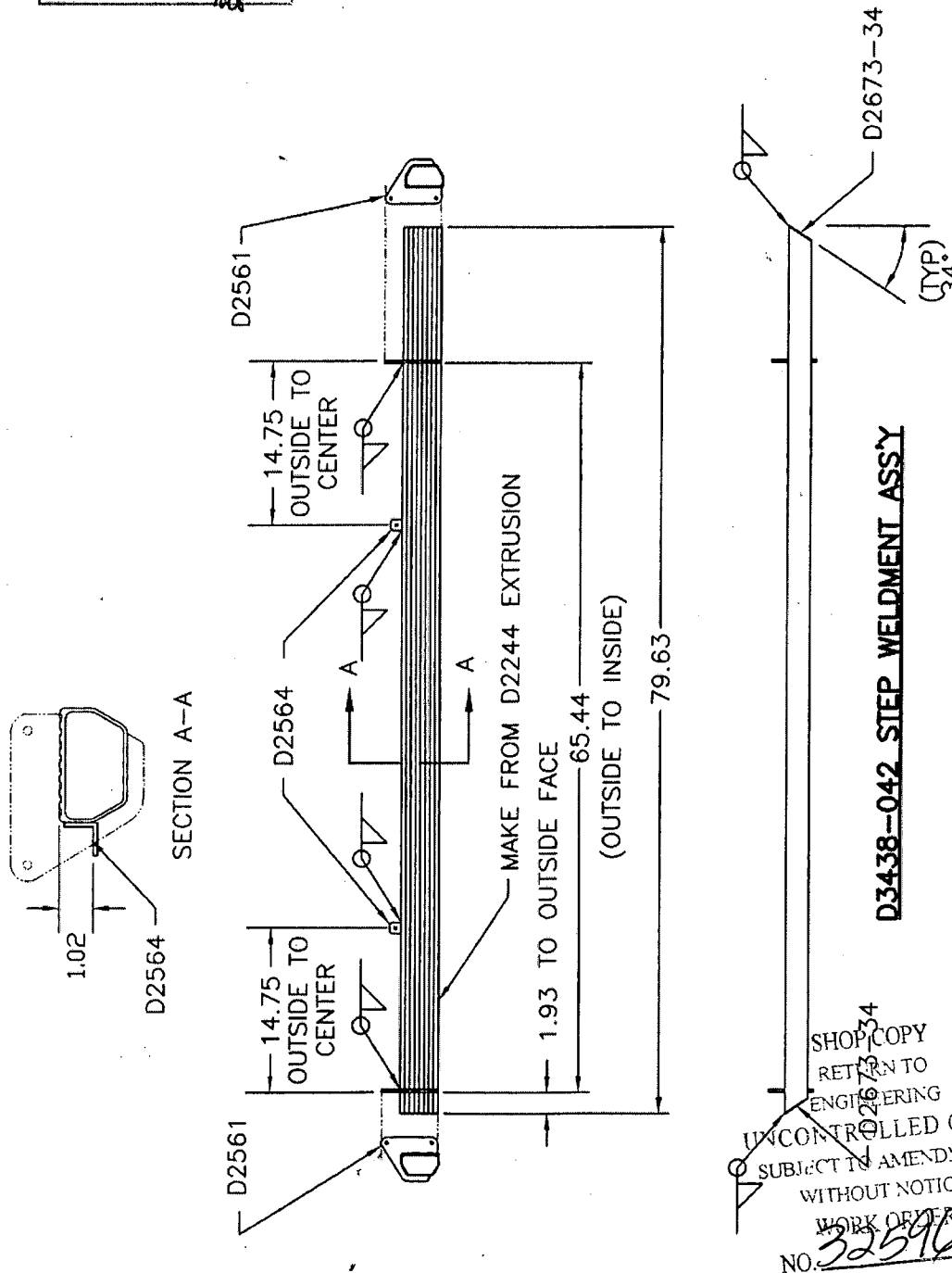
NOTE: Date & initial all entries

DART

| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3438 | REV. A SHEET 1 OF 1 |
| DATE 05.05.09 | | TITLE STEP WELDMENT ASSEMBLY | SCALE 1:1 |
| A | 05.05.09 | NEW ISSUE | |

RELEASED

05-05-22 [Signature]



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CENTER
NO. 32596

NOTES:

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1
WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

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